



Dart Aerospace Ltd.
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REPRINT

D4635-141

Job Sheet 167079-H



Part No: D4635-141

Job Qty: 1 ea

Part Name: Fwd Ceiling Replacement Panel Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 10/24/17

Job Tracking No:

Due Date: 11/10/17

Created By: Mario Poulin

Type: SOLD

Description:

Note: DWG D4635 REV F SHEET 9 IPP Rev. A 12/08/09 New Issue DL IPP Rev B 12/11/08 Doc Release DL IPP Rev. C Dwg. Update 13/07/09 DL ver: DD IPP Rev D Dwg Update 13/12/09 DL Ipp Rev. E Dwg Update 14/01/09 DL IPP Rev. F Dwg. Update 15/01/27 DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	11/9/17	11/9/17	0.00	0.00	Start Up Container		M.L. 18-3-28
100	HandThermo	1 pcs	11/9/17	11/9/17	0.00	1.65	HandFinish4		M.L. 18-3-28
110	Small Fab	1 pcs	11/10/17	11/10/17	0.00	1.47	Small Fab		M.L. 18-3-28
120	QC	1 pcs	11/10/17	11/10/17	0.00	0.00	QC5		38
130	Packaging	1 pcs	11/10/17	11/10/17	0.00	0.00	Packaging3		M.L. 18-3-28
140	QC21-SA	1 Ea	11/10/17	11/10/17	0.00	0.00	QC21		M.L. 18-3-28

Part Op 100 - Pick Kit

Descriptions: 110 - Assemble as per Dwg D4635-141 Bond foam core to inside of panel 3M Scotch Weld 1300

Batch: _____ 1- Scuff bonding surface to eliminate in-perfections and increase bonding and clean with wash& wipe 2- Locate and glue down Channel Assy, angles, brackets, and mounting pads using 3M Plastic welder II. (see note 8) Batch # _____ Expiry Date _____ 3- Apply labels as per Dwg. and seal with 3M 3950 edge sealer (see note 9) Batch: _____

120 - QC5- Inspect part completeness to step on W/O

130 - Identify as per dwg & Stock Location: _____

140 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D4635-1	Fwd Ceiling Panel, LH	1 Ea (1 ea)	90-Start up Operation	
D4669-1	Bracket	2 Ea (2 ea)	90-Start up Operation	
D4695-041	Channel Assembly, LH	1 Ea (1 ea)	90-Start up Operation	
D4732-29	Label	1 Ea (1 ea)	90-Start up Operation	
D4732-33	Label	1 Ea (1 ea)	90-Start up Operation	
D4732-5	Label	1 Ea (1 ea)	90-Start up Operation	
D4732-9	Label	1 Ea (1 ea)	90-Start up Operation	
D5022-1	Foam, Side Panel, Fwd	1 Ea (1 ea)	90-Start up Operation	
MPNY-750S-9-C	Mounting Pad	7 pcs (7 ea)	90-Start up Operation	

M.L. 002019

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	D4635-1	1	2	0
	D4669-1	2	12	0
	D4695-041	1	8	0
	D4732-29	1	0	0
	D4732-33	1	1	0
	D4732-5	1	0	0
	D4732-9	1	4	0
	D5022-1	1	5	0
	MPNY-750S-9-C	7	216	0
Part Specifications				
Specifications could not be found.				

Plex 3/28/18 8:14 AM dart.leroux.jason



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Container No: S055862



Part: D4635-141

Job No: 167079-H

Serial No/Batch: S055862

Revision: F

Inspector:

Date: 03/28/18